

## CLAIMS:

- Sub B1
1. An assembly for handling and packaging pharmaceutical dosage forms, including:
    - (a) an infeed structure for accepting a series of dosage forms including a surface movable in a downstream direction in a downstream direction, a laning structure defining a plurality of lanes extending in said downstream direction and having a downstream end, and a plenum structure extending from said infeed structure to said laning structure including a guide portion for guiding dosage forms carried by said surface into said laning structure;
    - (b) a form handling device for receiving dosage forms and transporting dosage forms from said laning structure to a packaging device;
    - (c) a dump gate having a closed position wherein said dump gate blocks said lanes at said downstream ends thereof, whereby dosage forms will accumulate in said lanes when said dump gate is in said closed position and an open position in which said dump gate does not block the lanes; and
    - (d) a timed controller for opening said dump gate after said handling device receives dosage forms whereby debris will be carried downstream out of said laning structure after said form handling device receives dosage forms from said laning structure.
  2. The assembly of claim 1 wherein said timed controller further comprises a computer communicating with said form handling device and said dump gate.
  3. The assembly of claim 1, further comprising a guide wall structure defining said guide portion and including a curved portion.
  4. The assembly of claim 3 wherein said guide wall structure also defines said plenum structure, said plenum structure including a plenum entry and said guide wall structure being shaped to guide dosage forms so that dosage forms enter said plenum structure at said plenum entry adjacent a first side of said laning structure and travel in a lateral direction transverse to said

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downstream direction toward a second side of said laning structure before entering said lanes.

5        5.        The assembly of claim 3 wherein said curved portion includes a member adjacent said plenum entry for relieving jamming of dosage forms.

6.        The assembly of claim 5, wherein said member comprises a movable member and further comprising a biasing means for vibrating said movable member to agitate dosage forms.

10        7.        The assembly of claim 1 wherein said laning structure includes a surface for supporting dosage forms, said surface sloping in said downstream direction to said dump gate so that debris is carried out of said laning structure by said surface when the dump gate is in the open position.

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